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D3302-1

Job Sheet 182195



Part No: D3302-1

Job Qty: 20 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/20/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: d3302 REV B2 IPP Rev: A 04.09.02 New issue KJ/JLM IPP Rev: B Now on Waterjet 07-06-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		9/10/18	0.00	0.00	Start Up Waterjet		DR 18/08/22
100	Waterjet	20 pcs		9/10/18	0.00	1.52	Waterjet1		DR 18/08/22
110	QC	20 pcs		9/10/18	0.00	0.00	QC2 Waterjet-1		DR DAS
120	QC	20 pcs		9/10/18	0.00	0.00	QC8-2		38
130	Small Fab	20 pcs		9/10/18	0.00	0.83	Small Fab-3		N/A 9-89
140	Brake NC	20 pcs		9/10/18	0.00	2.95	Brake NC 2		52
150	QC	20 pcs		9/10/18	0.00	0.00	QC5		
160	HandFinish	20 pcs		9/10/18	0.00	1.54	HandFinish1		DR 2018/10/21
170	QC	20 pcs		9/10/18	0.00	0.00	QC3		OCT 10 2018 68
180	Packaging	20 pcs		9/10/18	0.00	0.00	Packaging3-1	5-454 DAS	9-89
190	QC21-SA	20 Ea		9/10/18	0.00	0.00	QC21	2-89 OCT 15 2018	

Part Op 100 - 1-Cut as per Dwg D3302 Dwg Rev: B2 Prog Rev: B2 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Deburr break all unmarked sharp edges 0.005 to 0.010

140 - Form as per Dwg D3302

150 - QC5- Inspect part completeness to step on W/O

160 - Chemical Conversion Coat per QSI005 4.1

170 - QC3- Inspect Part Finish

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	15.4200 sf (.771 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	15	185	0

Part Specifications

Specifications could not be found.



Container No: S104295

Part: D3302-1

Job No: 182195

Serial No/Batch: S104295

Revision: B2

Inspector:

Exp Date:

Instructions: Various STC's

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www.dartaerospace.com

Date: 08/22/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					